



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-796-021
Job Sheet 174908



Part No: D119-796-021

Job Qty: 1 ea

Part Name: AW119 Standard Landing Gear Assembly - Standard OEM Protection



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/23/18

Job Tracking No:

Due Date: 6/4/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D119-796-021 REV A, IIN-D119-796 REV F IPP REV:A NEW ISSUE 15-05-012 JLM VERIFIED BY:DD
IPP REV:B 15.08.25 AS PER IIN REV:E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

MAY 30 2018

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/2/18	0.00	0.00	Start Up Stores/Pkg-1		MAY 30 2018
100	Packaging	1 pcs		6/2/18	0.00	0.00	Packaging1-1		
110	HandFinish	1 pcs		6/4/18	0.00	6.25	HandFinish4		DA6
120	QC	1 pcs		6/4/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		6/4/18	0.00	0.00	Packaging3-1		9-89
140	QC21-FG	1 Ea		6/4/18	0.00	0.00	QC21		9-89

Part Op 100 - Photocopy bluefile and create labels as per PPP D119-796-021 chg 003/ D119-646-041 paper work
Descriptions: 110 - ASSEMBLE AS PER DWG AND NOTES 8,9,10,11 ASSEMBLE WITH PROSEAL BATCH: 21 2-INSTALL
DECAL D2729-4
130 - Identify and pack for shipping as per PPP D119-796-021 Location: _____ PPP Rev: _____



Container No: S076413

Part: D119-796-021

Job No: 174908

Serial No/Batch: S076413

Revision: A / F

Inspector:

Exp Date:

Instructions: 05/30/2018

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/30/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C46A	Bolt	8 Ea (8 ea)	90-Start up Operation	5041155
AN3C50A	Bolt	16 Ea (16 ea)	90-Start up Operation	5019395
AN4C6A	Bolt	24 Ea (24 ea)	90-Start up Operation	5027515
D2652	Bushing	48 Ea (48 ea)	90-Start up Operation	5054604
D3407-041	Tow Ring	2 Ea (2 ea)	90-Start up Operation	5058326
D3417-5	Washer	4 Ea (4 ea)	90-Start up Operation	5059573 X 8
D3456-1	Washer	2 Ea (2 ea)	90-Start up Operation	5050328
D3672-3	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	5027022
D3672-7	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	5050052 F1 57442
D3883-1	Saddle, Outboard LH	2 Ea (2 ea)	90-Start up Operation	5049493
D3883-2	Saddle, Outside RH	2 Ea (2 ea)	90-Start up Operation	5067912
D3884-1	Saddle, Inside LH	2 Ea (2 ea)	90-Start up Operation	5049436
D3884-2	Saddle, Inside RH	2 Ea (2 ea)	90-Start up Operation	5070391
D3886-041	Lug Assembly	4 Ea (4 ea)	90-Start up Operation	5061556
MS21043-3	Nut	24 Ea (24 ea)	90-Start up Operation	5031415
MS21043-4	Nut	26 Ea (26 ea)	90-Start up Operation	5056040
MS21043-5	Nut	8 Ea (8 ea)	90-Start up Operation	5024470
MS21250-05048	Bolt (Use Ms21250-05-048)	8 Ea (8 ea)	90-Start up Operation	5039034
MS21920-28	Clamp	2 Ea (2 ea)	90-Start up Operation	5071412
NAS1149C0332R	Washer	24 Ea (24 ea)	90-Start up Operation	5049837
NAS1149C0432R	Washer	48 Ea (48 ea)	90-Start up Operation	5050052
NAS1149C0532R	Washer	16 Ea (16 ea)	90-Start up Operation	5055951
D119-646-041	AW119 Replacement Skidtube with Wearpads - Fits LH or RH	2 Ea (2 ea)	110-HandFinish	5057746 X 5059835 1K 505956
D119-796-151	Fwd Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	110-HandFinish	5077462
D119-796-251	Aft Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	110-HandFinish	5077522

Job Allocations

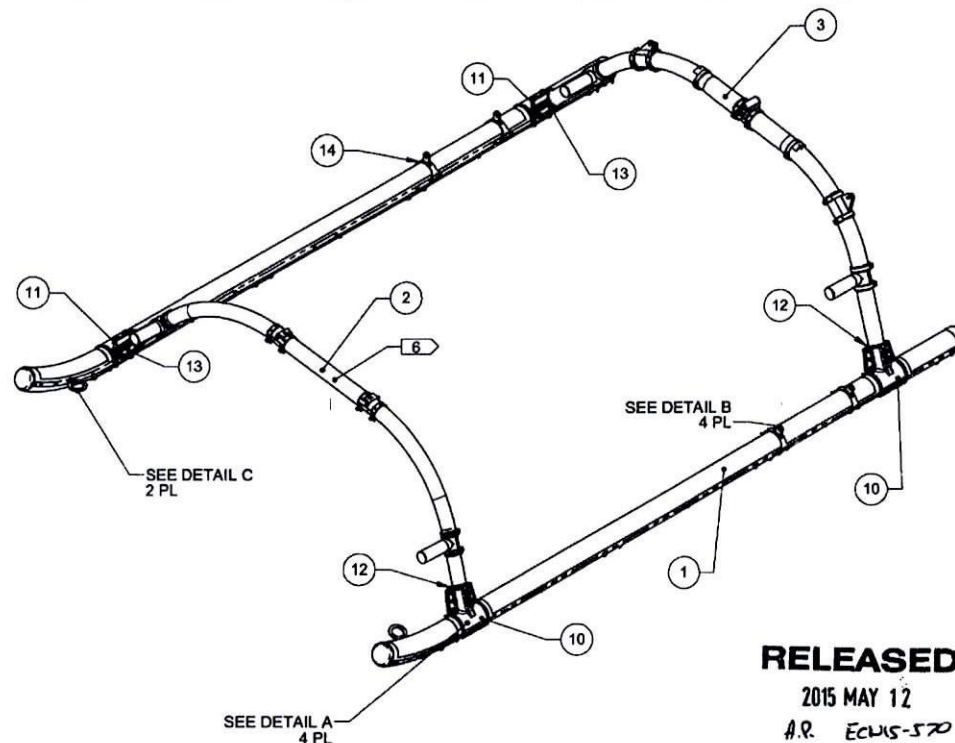
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C46A	8	197	0
	AN3C50A	16	116	0
	AN4C6A	24	427	0
	D2652	48	532	0
	D3407-041	2	14	0
	D3417-5	4	35	0
	D3456-1	2	105	0
	D3672-3	48	1,278	0
	D3672-7	48	595	0
	D3883-1	2	8	0
	D3883-2	2	2	0
	D3884-1	2	11	0
	D3884-2	2	10	0
	D3886-041	4	18	0
	MS21043-3	24	951	0
	MS21043-4	26	631	0
	MS21043-5	8	151	0
	MS21250-05048	8	5	0
	MS21920-28	2	85	0
	NAS1149C0332R	24	4,896	0
	NAS1149C0432R	48	2,911	0
	NAS1149C0532R	16	189	0
110-HandFinish	D119-646-041	2	2	0
	D119-796-151	1	0	0
	D119-796-251	1	0	0

Part Specifications

Specifications could not be found.

Plex 3/23/18 9:09 AM Dart.Gagnon.Michelle

ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-021	STD GEAR WITH STD WEARPADS
1	2	D119-646-041	STD SKIDTUBE WITH STD WEARPADS
2	1	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
3	1	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
4	48	D2652	BUSHING
5	2	D3407-041	TOW RING
6	4	D3417-5	WASHER
7	2	D3456-1	WASHER
8	48	D3672-3	PHENOLIC WASHER
9	48	D3672-7	PHENOLIC WASHER
10	2	D3883-1	SADDLE, OUTBOARD LH
11	2	D3883-2	SADDLE, OUTBOARD RH
12	2	D3884-1	SADDLE, INBOARD LH
13	2	D3884-2	SADDLE, INBOARD RH
14	4	D3886-041	LUG ASSEMBLY
15	8	AN3C46A	BOLT
16	16	AN3C50A	BOLT
17	24	AN4C6A	BOLT
18	24	MS21043-3	NUT, SELF-LOCKING
19	26	MS21043-4	NUT, SELF-LOCKING
20	8	MS21043-5	NUT, SELF-LOCKING
21	8	MS21250-05048	BOLT
22	24	NAS1149C0332R	WASHER
23	48	NAS1149C0432R	WASHER
24	16	NAS1149C0532R	WASHER



D119-796-021 STD GEAR WITH STD WEARPADS

RELEASED
2015 MAY 12
A.R. ECWIS-570

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194908
MAR 27 2018

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: N/A
4) UNITS: N/A
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: INSTALL D2729-4 RED DECAL IN LOCATION SHOWN
7) WEIGHT: 122.7 LBS

APPROVED	A	NEW ISSUE	AP	15.04.01
	REV.	DESCRIPTION	BY	DATE
	DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AP		
	CHECKED	AJS	DRAWING NO.	REV. A
	MFG. APPR.	DD	D119-796-021	SHEET 1 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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MS21250-05048 BOLT
NAS1149C0532R WASHER
D3672-7 WASHER
2 PL
10

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)

AN3C50A BOLT
D3672-7 WASHER
D2652 BUSHING
4 PL
10

D3884-1 SADDLE (LHS)
D3884-2 SADDLE (RHS)

D3672-7 WASHER
NAS1149C0532R WASHER
MS21043-5 NUT
2 PL
10

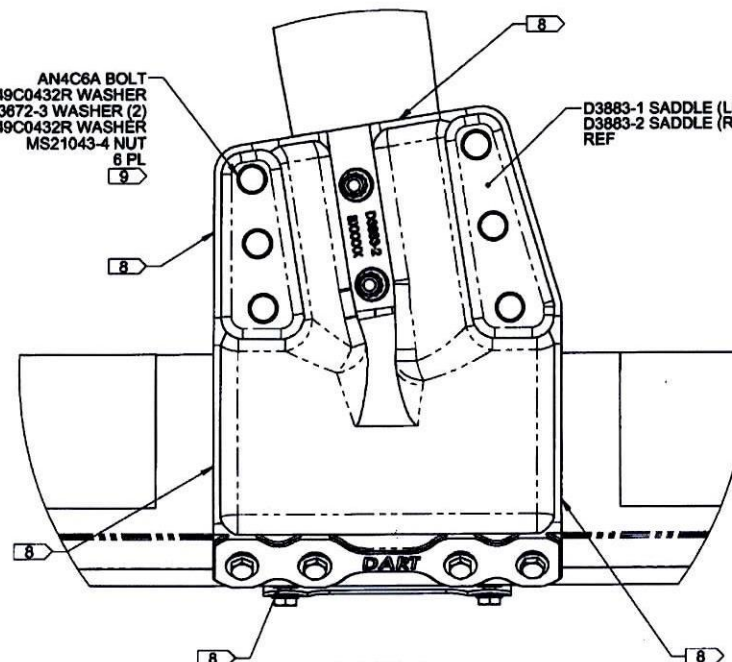
D2652 BUSHING
D3672-7 WASHER
NAS1149C0332R WASHER
MS21043-3 NUT
4 PL
10

DETAIL A
4 PL

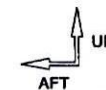


AN4C6A BOLT
NAS1149C0432R WASHER
D3672-3 WASHER (2)
NAS1149C0432R WASHER
MS21043-4 NUT
6 PL
9

D3883-1 SADDLE (LHS)
D3883-2 SADDLE (RHS)
REF



DETAIL A



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2015 MAY 12

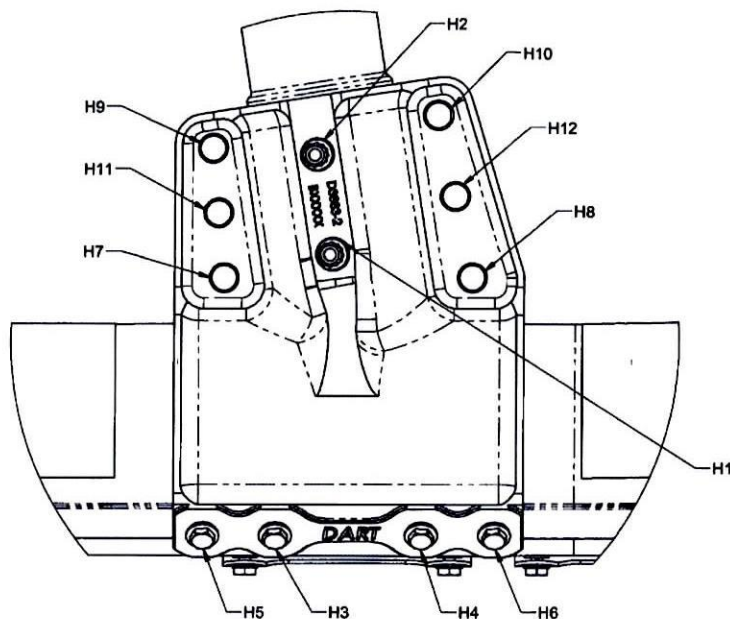
A.P. EN 15-570

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A CONTINUOUS BEAD OF SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT IN THE LOCATIONS SHOWN INCLUDING THE FOLLOWING:
 - A) ALONG SADDLE/CROSSTUBE INTERFACE
 - B) BETWEEN THE SADDLE FLANGES
 - C) ALONG SADDLE/SKIDTUBE INTERFACE
- 9) LIGHTLY TIGHTEN ALL BOLTS IN THE NUMERICAL ORDER SPECIFIED ON SHEET 3, THEN TIGHTEN TO SPECIFIED TORQUE IN TABLE 1.
- 10) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) ALL NUTS TO BE INSTALLED ON THE INBOARD SIDE

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DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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SUPPLEMENTAL VIEW - TORQUE SEQUENCE

TABLE 1: TORQUE SEQUENCE AND MAX TORQUE

TORQUE SEQUENCE	PART NUMBER	TORQUE
H1	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H2	MS21250-05048	66-85 IN-LBS (7.3 - 9.6 n-m)
H3	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H4	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H5	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H6	AN3C50A	15-25 IN-LBS (1.7 - 9.6 N-m)
H7	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H8	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H9	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H10	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H11	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)
H12	AN4C8A	50-70 IN-LBS (5.7 - 7.9 N-m)

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2015 MAY 12

A.P. EN 15-STD

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CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	D119-796-021	SHEET 3 OF 4
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DE APPR.	DS	STD GEAR WITH STD WEARPADS	NTS
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D3407-041 TOW RING
D3417-5 WASHER

9

INBOARD

D3417-5 WASHER
D3458-1 WASHER
MS21043-4 NUT

8 9 11

DETAIL C
2 PL

D2852 BUSHING
NAS1149C0332R WASHER
MS21043-3 NUT
2 PL

8 9 10

INBOARD

D3886-041 LUG ASSEMBLY

9

D2852 BUSHING
AN3C46A BOLT
2 PL

8 9 10

DETAIL B
4 PL

RELEASED

2015 MAY 12

A.P. Ecn15-570

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) INSTALL WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) APPLY FAY SEAL AND FILLET SEAL USING SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 10) TORQUE AN3 HARDWARE TO 20-25 IN-LBS
- 11) TORQUE AN4 HARDWARE TO 50-70 IN-LBS

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